

Work Order ID 65844

Wednesday, January 26, 2011 11:34:50 AM



Page 1

Item ID: D3675-5

Accept



Setup Start



Revision ID:

Item Name: Sliding Door Bracket

Stop



Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: [Signature] Date: 11-01-26 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3675	C

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3675

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

304 .040

B11-1-31

5

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B11-1-31

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

Subtotal

45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3675	0.00 0.00		SB 11/02/10		⑤			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/1/02/21		⑤ ⑤			
150 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 3:30 OVEN TEMPERATURE: 350° FINISH TIME: 4:00	0.00 0.00				5 BK 11-02-14			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				5	0	11/02/15	llb
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>237</u> Memo	0.00 0.00				11/2/15	(5.0)		
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				CK	11/02/15		MF 11-02-15

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 11:34:57 AM

Page 1

Work Order ID: 65844



Parent Item: D3675-5



Parent Item Name: Sliding Door Bracket

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.01.11 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	182.9000	0.4092	1.722947			



304/316 .040 Sheet



B11-1-31

Location

Loc Qty

Loc Code

MAT

182.9

115953

32.1

116437

54.8

116623

96

116623

(5)

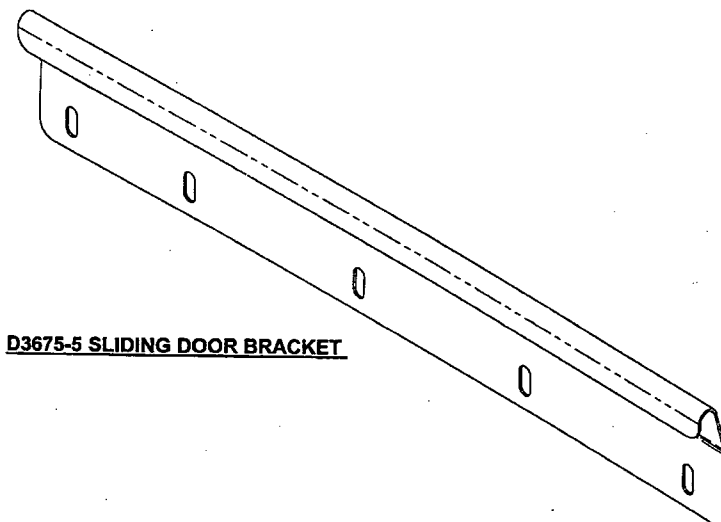
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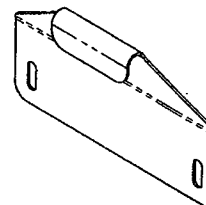
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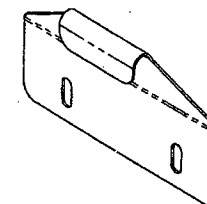
NOTE: Date & initial all entries



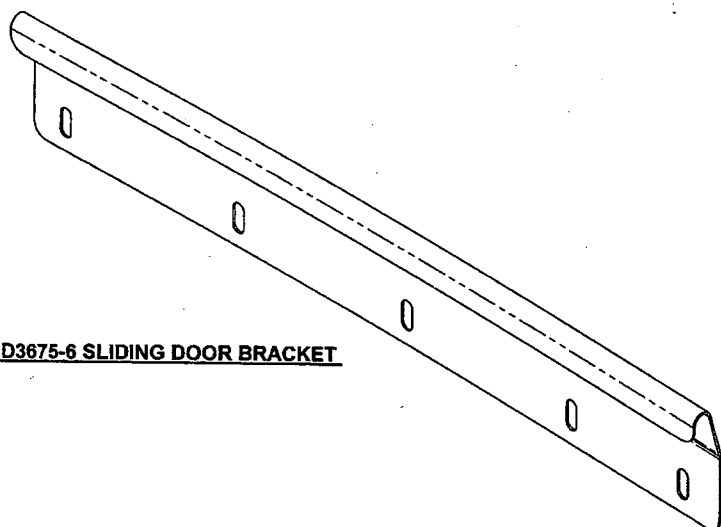
D3675-5 SLIDING DOOR BRACKET



D3675-1 SLIDING DOOR BRACKET



**D3675-3 SLIDING DOOR BRACKET
(HINGE PANEL MOD)**



D3675-6 SLIDING DOOR BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65844

PL 11-01-26

RELEASED
2010-12-23

C	ADD -51-SFI-6 BRACKET	MB	10.12.17
B	ADD -3 FOR HINGE PANEL MOD.	AJS	08.11.03
A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>AJS</u>		
DRAWN	<u>J</u>		
CHECKED	<u>JP</u>		
MFG. APPR.	<u>JP</u>		
APPROVED	<u>JP</u>		
DE APPR.	<u>JP</u>		
DATE	10.12.17		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3675 REV. C TITLE SLIDING DOOR BRACKET SCALE (COMPOSITE DOOR) NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

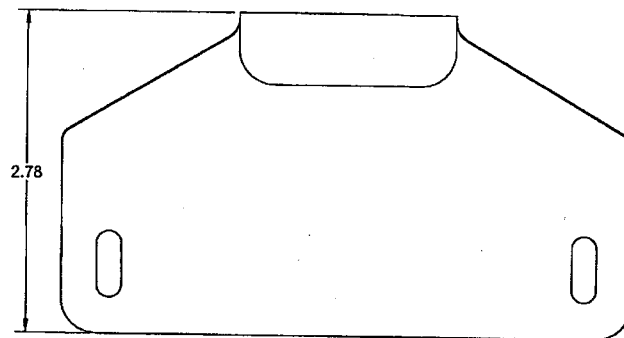
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

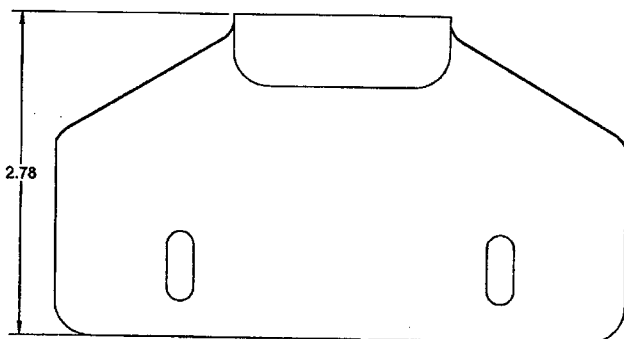
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

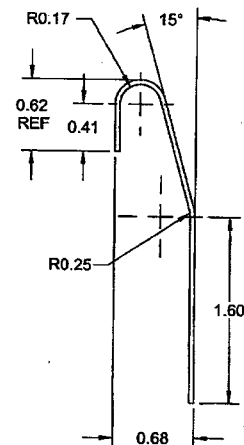
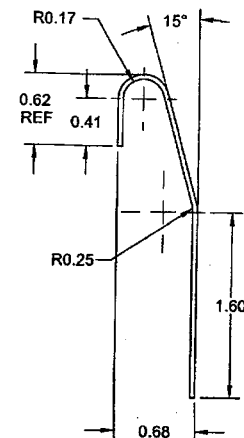
NOTE: Date & initial all entries



D3675-1 SLIDING DOOR BRACKET
(MAKE FROM D3675-1F)



D3675-3 SLIDING DOOR BRACKET
(MAKE FROM D3675-3F)
(HINGE PANEL MOD)



W1065844

RELEASED
2010-12-23

NOTES:

- 1) MATERIAL: SEE SHEET 5
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs EACH
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3675	SHEET 2 OF 6
APPROVED		TITLE	SLIDING DOOR BRACKET
DE APPR.		(COMPOSITE DOOR)	SCALE
DATE	10.12.17		NTS
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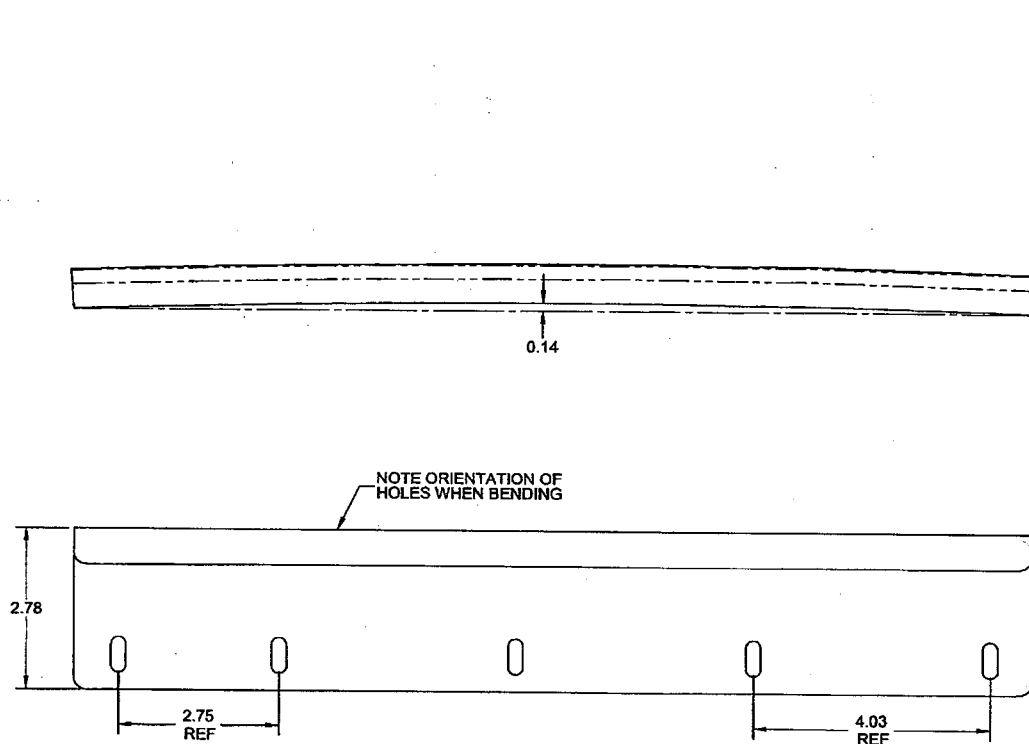
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3675-5 SLIDING DOOR BRACKET
(MAKE FROM D3675-5F)

NOTES:

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-5" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.67 lbs EACH
- 8) THE D3675-5 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-3 BRACKET.

DESIGN	<i>AKS</i>	DART AEROSPACE LTD	
DRAWN	<i>AKS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AKS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>AKS</i>	D3675	SHEET 3 OF 6
APPROVED	<i>AKS</i>	TITLE	SLIDING DOOR BRACKET
DE APPR.	<i>AKS</i>	(COMPOSITE DOOR)	SCALE
DATE	10.12.17		NTS

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RELEASED
2010-12-23

21065844

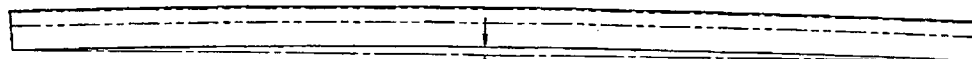
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

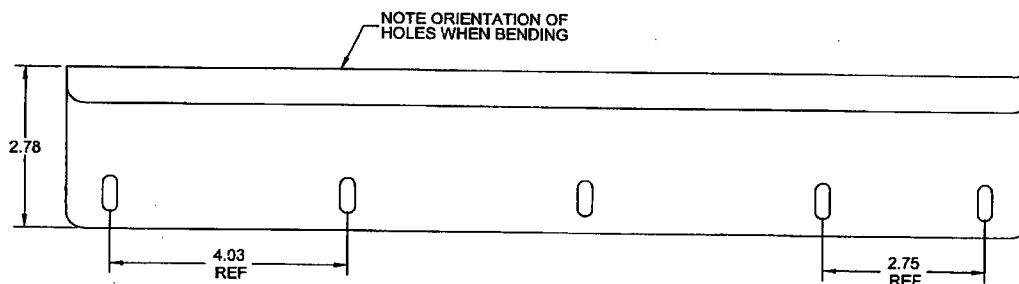
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



0.14



NOTE ORIENTATION OF HOLES WHEN BENDING

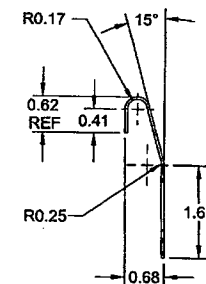
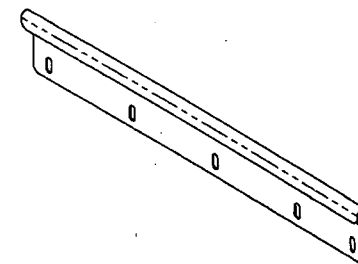
2.78

4.03
REF

2.75
REF



D3675-6 SLIDING DOOR BRACKET
(MAKE FROM D3675-5F)



w/0 65844

RELEASED
2010-12-23
MP

NOTES:

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-6" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.67 lbs EACH
- 8) THE D3675-6 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-4 BRACKET.

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D3675	SHEET 4 OF 6
APPROVED	JP	TITLE	SLIDING DOOR BRACKET
DE APPR.	JP	(COMPOSITE DOOR)	SCALE
DATE	10.12.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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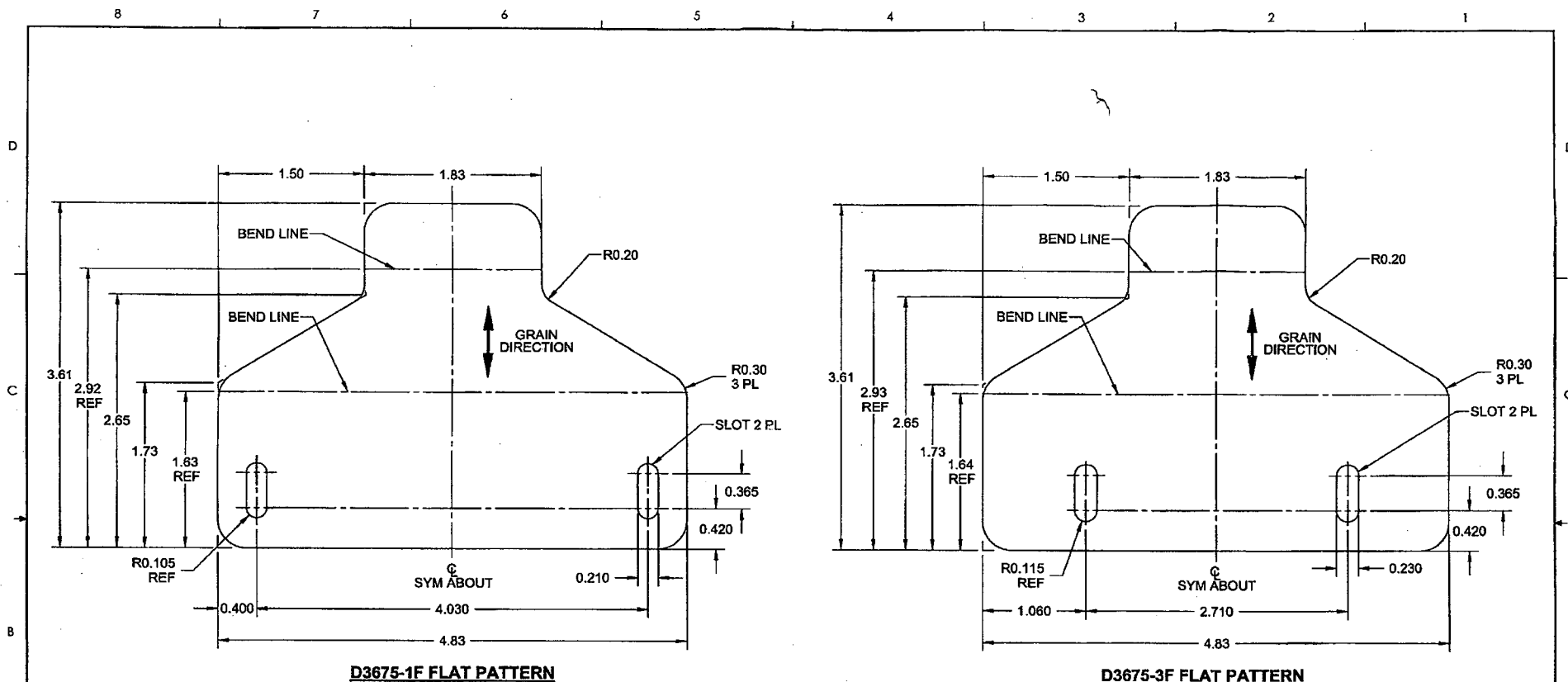
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



w/o 65844

RELEASED
2010-12-23

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs EACH

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	q	DRAWING NO.	REV. C
MFG. APPR.	SD	D3675	SHEET 5 OF 6
APPROVED	SD	TITLE	SLIDING DOOR BRACKET
DE APPR.	#	(COMPOSITE DOOR)	SCALE NTS
DATE	10.12.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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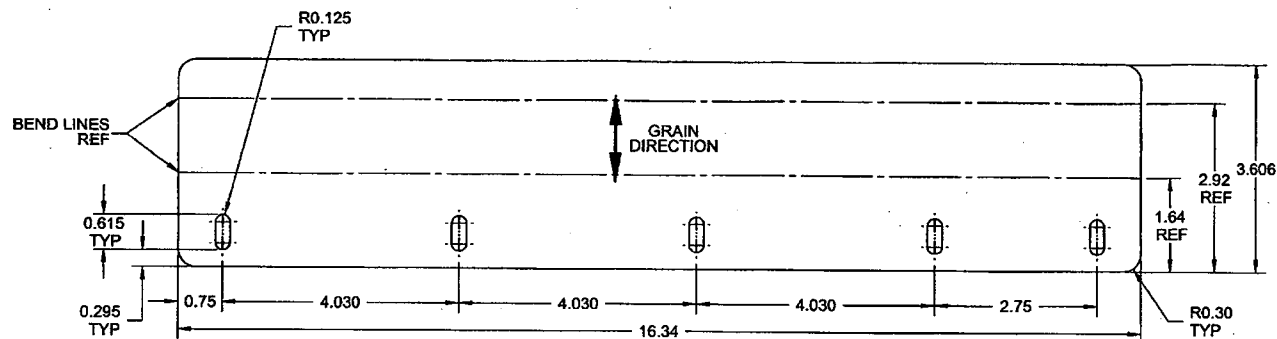
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3675-5F FLAT PATTERN

w/o 65844

RELEASED
2010-12-23

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

DESIGN	<i>AJS</i>	DART AEROSPACE LTD	
DRAWN	<i>h</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>ES</i>	D3675	SHEET 6 OF 6
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	SLIDING DOOR BRACKET (COMPOSITE DOOR)	NTS
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